

Work Order ID 79082

79082

Page 1

January-19-12 1:41:42 PM

Item ID: D2803-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 19/01/2012 Start Qty: 500 ***5*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 500 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/6/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2803	Rev B

100 0.00

100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per File d2803-2
 6061 500 X 10 Dwg Rev: 8
 Prog Rev: 8
 2-Deburr if necessary

110 0.00

110 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Machine as per folio FA102

120 0.00

120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

January-19-12 1:41:42 PM

Item ID: D2803-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 19/01/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

145	QC3 Inspect Part Finish	0.00							
145									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 8 12-1-29
 8 12-1-30
 8x4 m/l 2/04/30
 Pro →

W/O: 79082		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/1/30	145	change step to QC 7 inspection	<i>[Signature]</i>	12.02.01			<i>[Signature]</i> 12/1/30

Part No: D 2803-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>148</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/1/31 80

12/12/11 20

1201-31
8

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Picklist Print

January-19-12 1:41:46 PM

Page 1

Work Order ID: 79082

79082

Parent Item: D2803-2

D2803-2

Parent Item Name: Bracket

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A 00.11.06New IssueEC
 IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM
 IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP
 Rev:D add qc3 DD 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	24.1000	1.9167	10.08789			

M6061T6B0 500X10 0000

6061-T6 Bar .500 x 10.00

**

B 12-1-25

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

118641

118641

8

6061 .500 x 10.00

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79082
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.759	✓		Dial Caliper	56 05
1.420	+/-0.001	1.420	✓			
Ø0.191	+0.005/-0.000	.192	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.507 x 0.250	+0.000/-0.001	.5065 x .243	✓			
12.411	+/-0.010	12.411	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.252	✓			
0.875	+0.000/-0.001	.8745	✓			
0.250	+0.000/-0.005	.246	✓			
0.125	+/-0.010	.130	✓			
0.125	+/-0.010	.130	✓			
0.500	+/-0.010	.504	✓			
0.125	+/-0.010	.130	✓			
0.188	+/-0.010	.190	✓			
0.562	+/-0.010	.564	✓			
0.125	+/-0.010	.130	✓			

Measured by: <i>SK/GR</i>	Audited by: <i>RE</i>	Prototype Approval:	N/A
Date: <i>12/01/2006</i>	Date: <i>12-1-29</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	<i>[Signature]</i>

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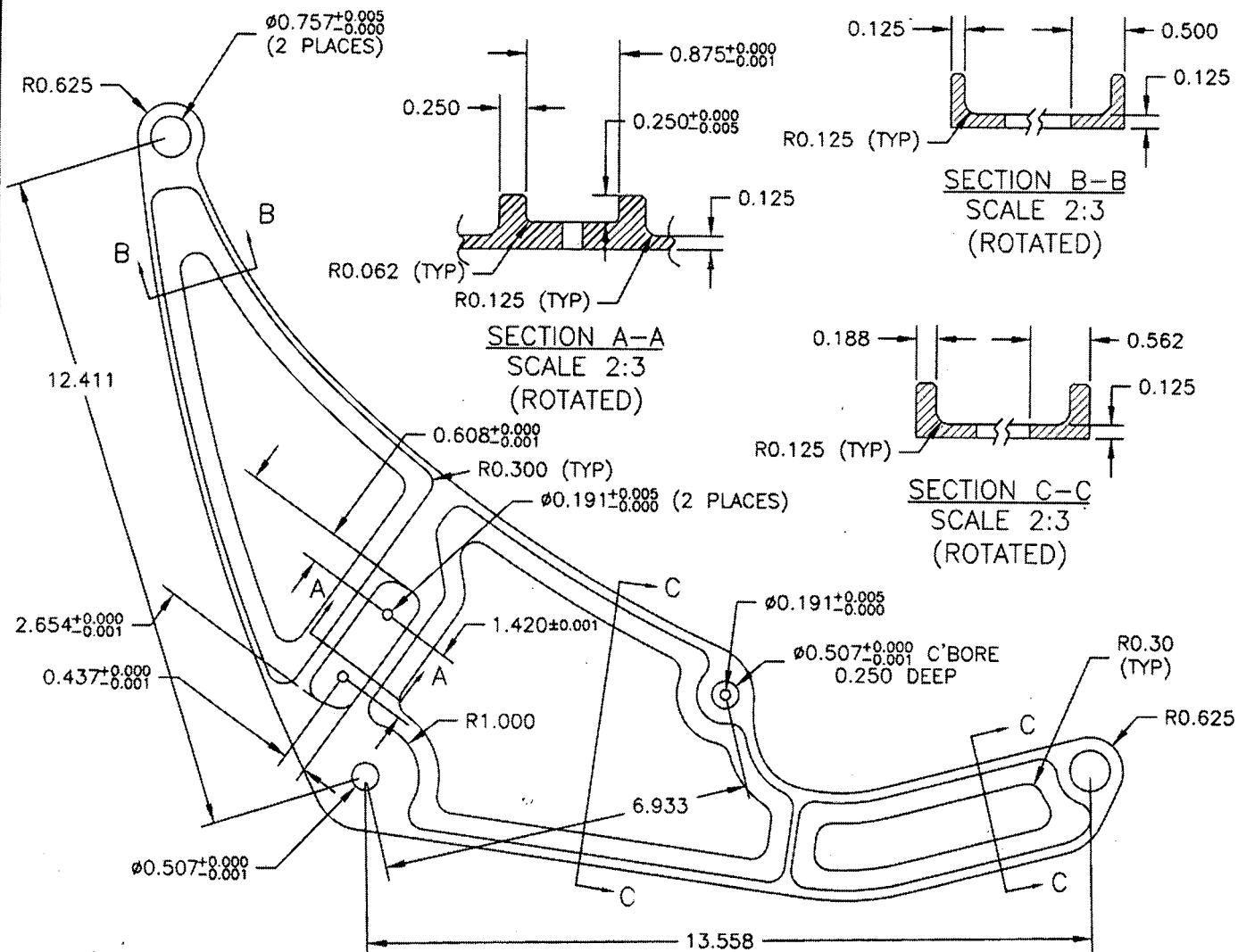
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03 11



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO 79082
M.L.J 12/01/19

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

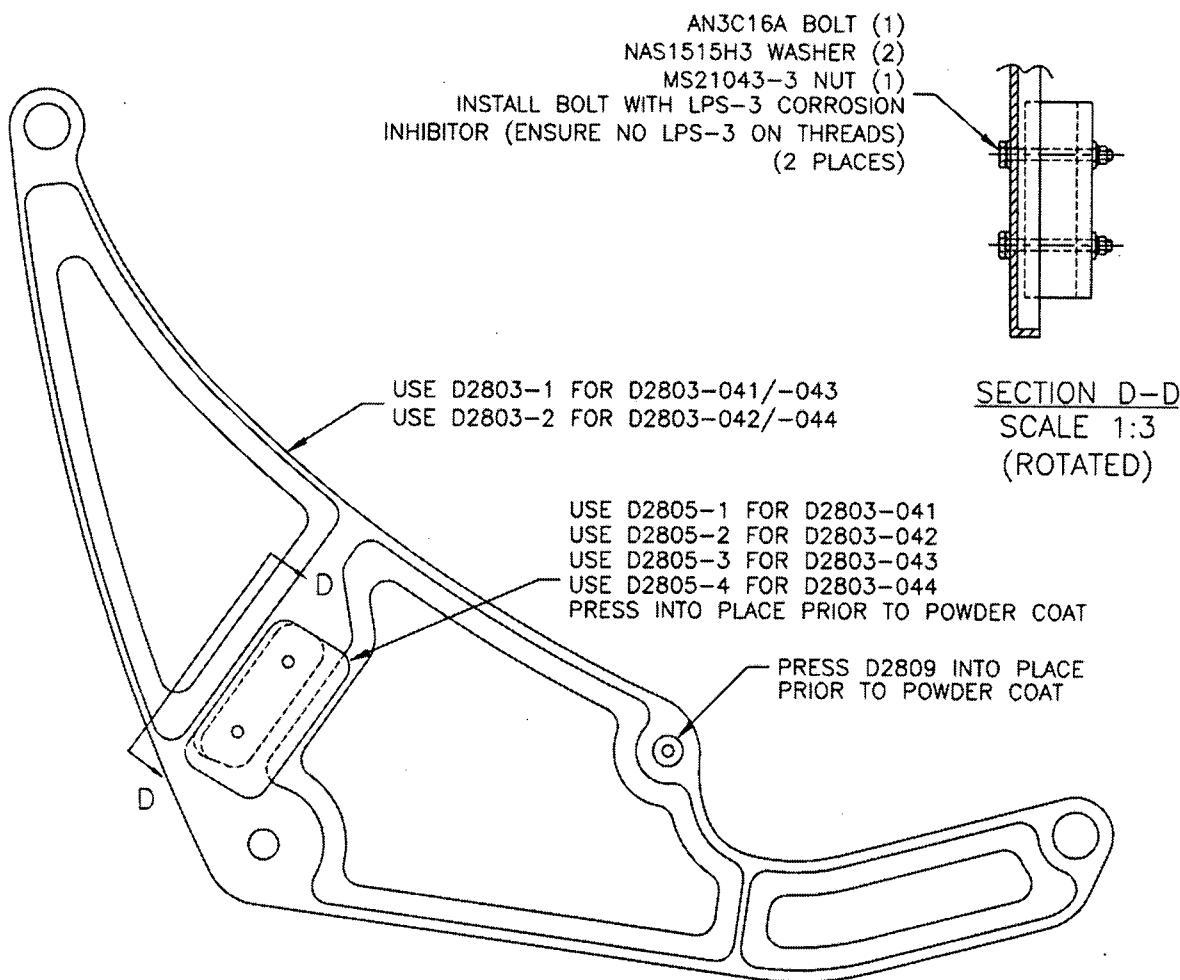
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NOTE: Date & initial all entries



79082

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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